

Please use new method

Dart Aerospace Ltd.

Date: Thursday, 3/23/2006 1:22:02 PM
 User: COSS systems

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L FWD X-TUBE
Job Number	: 26321		
Estimate Number	: 10553		
P.O. Number	: N/A	Part Number	: D206667103
This Issue	: 3/23/2006 S.O. No. : N/A	Drawing Number	: D206-667-143 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 25606	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 4/15/2006
Checked & Approved By	: <u>[Signature]</u>	Qty:	1 Um: Each
Comment	: Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

2.0	D6002115	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6002-115 Crosstube 17511

Check OD = 2.250"; ID = 1.750"

MB 06/03/29

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087 MB 06/03/29

2-Turn first side as per Folio FA087

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143. BC 06.03.30

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

BC 06.03.30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 26321

Part Number: D206667103

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Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA087

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

3-Polish entire outside surface of crosstube

4-Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

SG 06-03-30

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SG 06-03-30

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 06-03-30

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI.005 4.1

J.F. 06/04/11

9.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206L-fw and Folio FT017

DP 06-4-17

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg

USED FOR
P 206L-2206

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Process Sheet

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Drawing Name: 206L FWD X-TUBE

Job Number: 26321

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

D206-667-143 Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-143.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038 Or

Issue P/O: _____ LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 26321

Part Number: D206667103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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17.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

18.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

19.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

20.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip

21.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

22.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Drawing Name: 206L FWD X-TUBE

Job Number: 26321

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1 Support _____

24.0

MS20601AD4W8



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet _____

25.0

MS2192020

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20 Clamp _____

26.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 26321

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

10 AN5-7A Bolt

30.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

4 AN5-30A Bolt

see 2 H z...

31.0

AN960JD516

Washer



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

10 AN960JD516 Washer

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location: _____

PPP Rev: _____

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



u 06.06.12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/29/2006 8:00:18 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206L FWD X-TUBE
Job Number :	26321		
Estimate Number :	10553		
P.O. Number :		Part Number :	D206667103
This Issue :	3/29/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D206-667-143 REVB
First Issue :	3/23/2006	Project Number :	N/A
Previous Run :	25606	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :		Due Date :	4/15/2006
Comment :	Est Rev:F 05.09.01 Add holes for compatibility with Bell Skid tubes KJ/JLM		
		Qty:	1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

29.0	AN532A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Bolt

30.0	MS21042L5	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Nut

31.0	AN57A	Bolt
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Pick:Packing Kit
 Qty Part number Description Batch
 10 AN5-7A Bolt

32.0	AN530A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:Packing Kit
 Qty Part number Description Batch
 4 AN5-30A Bolt

Date: Wednesday, 3/29/2006 8:00:18 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 26321

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

10 AN960JD516 Washer

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location: _____

PPP Rev: _____

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



DART AEROSPACE LTD	Work Order: 26321
Description: Crosstube Assembly (206L High Fwd)	Part Number: D206-667-143
Inspection Dwg: D206-667-143 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.243	✓			
	1.982	+0.005/-0.000	1.986	✓			
	2.019	+0.005/-0.000	2.023	✓			
	2.058	+0.005/-0.000	2.062	✓			
	2.097	+0.005/-0.000	2.101	✓			
	2.136	+0.005/-0.000	2.140	✓			
	2.176	+0.005/-0.000	2.180	✓			
	2.201	+0.005/-0.000	2.204	✓			
				✓			
	0.125	+/-0.010	.132	✓			
	0.400 x 30°	+/-0.010	.213 900	✓			Should be .213
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.438	+/-0.030	4.438	✓			
SIDE B	104.98	+/-0.020	104.98	✓			
	2.240	+0.005/-0.000	2.245	✓			
	1.982	+0.005/-0.000	1.986	✓			
	2.019	+0.005/-0.000	2.024	✓			
	2.058	+0.005/-0.000	2.063	✓			
	2.097	+0.005/-0.000	2.101	✓			
	2.136	+0.005/-0.000	2.140	✓			
	2.176	+0.005/-0.000	2.180	✓			
	2.201	+0.005/-0.000	2.204	✓			
	0.125	+/-0.010	.130	✓			
	0.400 x 30°	+/-0.010	.213 900	✓			Should be .213
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.438	+/-0.030	4.438	✓			

Measured by: MB / BG	Audited by: SD	Prototype Approval:	N/A
Date: 06/03/29	Date: 06.03.30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	

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